Shp Sept. 4

Work Order ID 117798
May-05-14 8:00:28 AM

117798

Page 1

Split 5

Item ID: D4934-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Blade Assembly

Start Date: 5/05/14 **Start Qty:** 10.00 *10*
Required Date: 5/19/14 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MCJ **Date:** 14-05-05 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4934	Revision Nbr: A								14-08-02
110	Weld per dwg A/R Steel rod Batch: M19317	0.00							
110						10			JJL
Large Fab	**Memo**	0.00							
Large Fab	Clean with wash & wipe to remove oil								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 50 9-89
120						10	14-9-2		
QC	**Memo**	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
130						(15)	14-09-02		
QC	**Memo**	0.00							
Quality Control	VERIFY TENSILE STRENGTH AFTER WELDING AS PER DWG NOTE 8								

Item ID: D4934-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Blade Assembly

Start Date: 5/05/14 **Start Qty:** 10.00 *10*
Required Date: 5/19/14 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M135981 **Memo** ***MASK CARBIDE FACE PRIOR TO POWDERCOAT*** START TIME: 12:00 OVEN TEMPERATURE: 400° FINISH TIME: 12:30	0.00 0.00				10	0	14-9-3	DAS 34 9-89
150 *150* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				5			DAS 38 9-89 14-9-3
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: _____ **Memo** STOR	0.00 0.00				5		14/9/3	

Item ID: D4934-041
Revision ID:
Item Name: Blade Assembly

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 5/05/14 **Start Qty:** 10.00 *10*
Required Date: 5/19/14 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00				MLS 14-09-03			
Quality Control									

MF
14-9-03

Picklist Print

May-05-14 8:00:31 AM

Work Order ID: 117798

117798

Parent Item: D4934-041

D4934-041

Parent Item Name: Blade Assembly

Start Date: 5/05/14 **Required Date:** 5/19/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 13.09.06 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2741-NP		Manufactured	No				Each	0.0000		10			14-08-29
D2741-NP Blade (No paint)				1	117185			5	**				JBL
D4932-1-048		Manufactured	No		117791		Each	5	0.0000	10			14-08-29
D4932-1-048 KWS Carbide Wear Strip, 4.8" Long					117743			10	**				JBL

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

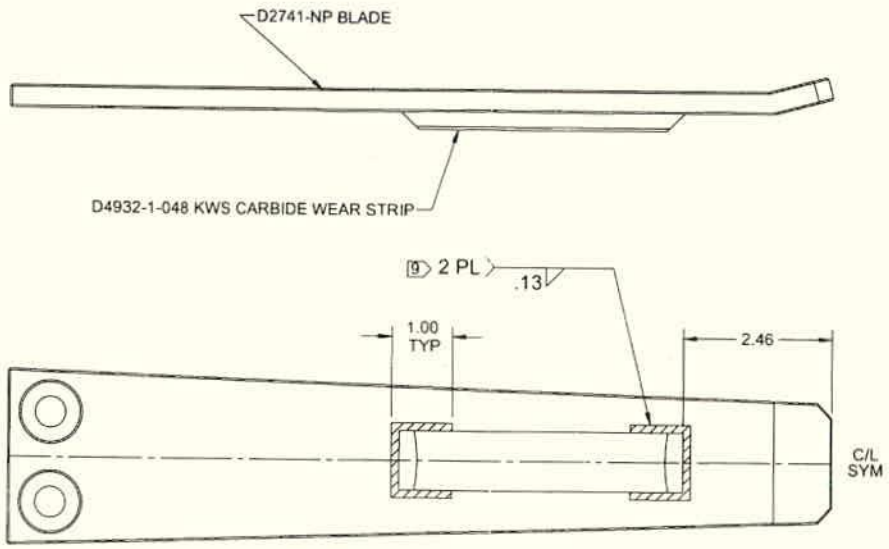
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4934-041	BLADE ASSY
1	1	D2741-NP	BLADE
2	1	D4932-1-048	KWS CARBIDE WEAR STRIP



117798 MCJ
14-05-05

RELEASED
2014-04-04

D4934-041 BLADE ASSY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" PER DART QSI 005 4.3.5.2 (EXCEPT FOR CARBIDE FACE)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: WITH DART P/N "D4934-041" PER DART QSI 044 METHOD 6.1
7) WEIGHT: 4.12 LBS
8) VERIFY TENSILE STRENGTH (AFTER WELDING) BY HARDNESS TEST PER ASTM E18 TO 34-40 HRC
9) WELDING: PER QSI 004

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DB	13.08.28

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4934	REV. A
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE BLADE	SCALE NTS
DE APPR.			
DATE	13.08.28		

[9:16:08 AM] Linda Lacelle: hi Mike, the D4934 blades with the welded carbide strips...do they still need to be masked?

[9:31:56 AM] Mike Petsche: I don't think so

[9:40:18 AM] Linda Lacelle: so is that a no? the drwg says to mask

[9:42:33 AM] Mike Petsche: I'm pretty sure we deviated them last time to nix the masking

[9:45:08 AM] Linda Lacelle: ok..thx

Mike Petsche